

# Work Order ID 73944

Tuesday, September 20, 2011 9:18:33 AM



Page 1

Item ID: DSK076

Accept



Setup Start



Revision ID:

Item Name: D2891-1 TURNING DETAIL

Stop



Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: R Date: 11-09-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK076	Rev A								

100	DOOSAN LATHE	0.00							
	Doosan	Memo							
Doosan Lathe	Turn blank for as per Folio FA046	0.00							
			SL	11/10/31					
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo							
Quality Control		0.00							
			SL	11/10/31					
120	QC8- Inspect parts - second check	0.00							
	QC	Memo							
Quality Control		0.00							
			SL	11-11-03					

10 0

10 0

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73944

Tuesday, September 20, 2011 9:18:33 AM



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Item ID: DSK076

Accept



Setup Start



Revision ID:

Item Name: D2891-1 TURNING DETAIL

Stop



Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Packaging

0.00

Packaging

Memo

Packaging

Identify and Stock in Kanban Location: NATO 50

JK

11-11-03

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

11/11/03

cmf  
11-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 9:18:38 AM

Page 1

Work Order ID: 73944

Parent Item: DSK076

Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 9/20/2011

Required Date: 9/26/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-003		Manufactured	No				Each	17.0000		10			
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Round Billet, 17-4



5h 10/10/31

Location

Loc Qty

Loc Code

MAT043

17

60943

3

66960

1

72807

13

B 53750

8

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73944
<b>Description:</b> Turning Detail for D2891-1		<b>Part Number:</b>	DSK076
<b>Inspection Dwg:</b> DSK076 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article      ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.278	2.279	2.279	2.279	2.279
B	3.702	3.722		3.722	3.712	3.712	3.712	3.712
C	2.564	2.584		2.572	2.572	2.573	2.573	2.573
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.464	2.484		2.472	2.472	2.473	2.473	2.473
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	2.964	2.984		2.971	2.972	2.973	2.973	2.973
I	0.913	0.933		.922	.922	.922	.922	.922
J	0.022	0.042		R.031	R.031	R.031	R.031	R.031
K	0.090	0.110		.098	.099	.098	.098	.098
L								
M								
N								
O								
P								

**Measured by:** SA      **Date:** 10/10/03

**Audited by:** JL      **Date:** 11/11/03

**Prototype Approval:**      **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	73944
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	110
Lathe Section								
A	2.274	2.279		2.275	2.277	2.278	2.279	2.279
B	3.702	3.722		3.712	3.712	3.712	3.712	3.712
C	2.564	2.584		2.573	2.573	2.573	2.573	2.573
D	0.718	0.738		0.726	0.726	0.726	0.726	0.728
E	0.090	0.110		0.101	0.101	0.101	0.101	0.101
F	2.464	2.484		2.473	2.473	2.473	2.473	2.473
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	2.964	2.984		2.973	2.973	2.973	2.973	2.973
I	0.913	0.933		0.922	0.922	0.922	0.922	0.925
J	0.022	0.042		0.031	0.031	0.031	0.031	0.031
K	0.090	0.110		0.097	0.097	0.098	0.098	0.097
L								
M								
N								
O								
P								

Measured by: SA Date: 11/10/31

Audited by: S Date: 11-11-03

Prototype Approval: Date:

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A	08.04.22	New Issue	KJ/JLM	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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